

**Work Order ID 62182**

Monday, September 20, 2010 12:47:33 PM



Page 1

Item ID: PB67-43001-261

Accept



Setup Start



Revision ID:

Stop



Item Name: Lever Arm

Start Date: 9/21/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-9-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100	FLOW WATER JET	0.00							
	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
6061 .250 <del>3154</del>	1-Cut as per Dwg B67-43001								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

mpc not pulled

B10-9-28



B10-9-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
						(12)			
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
140  Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Powdercoat Memo START TIME: 2:05 OVEN TEMPERATURE: 320° FINISH TIME: 2:35	0.00 0.00							

10/09/20

BL 10-9-30

12

BL 10-10-6

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/21/2010 Start Qty: 12.00

Required Date: 10/11/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							10/10/17 SP (120)
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>422</u>  Memo	0.00  0.00							10/10/17 SP (120)
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							10/10/12 JF MF 10-10-12

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

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Work Order ID: 62182



Parent Item: PB67-43001-261



Parent Item Name: Lever Arm

Start Date: 9/21/2010

Required Date: 10/11/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 05.06.07 New issue KJ/JLM  
IPP Rev:B 08-06-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.00 0		Purchased		No		100	f	36.0000	1.388	17.53263	16.656		



1810-9-28

6061-T6 Bar .250 x 6.00

Location	Loc Qty	Loc Code
MAT	12	
115212	12	
MAT01	24	
115165	24	

$$115212 \times 8 = 11.104$$

$$115165 \times 4 = 12 \text{ } 5.552$$

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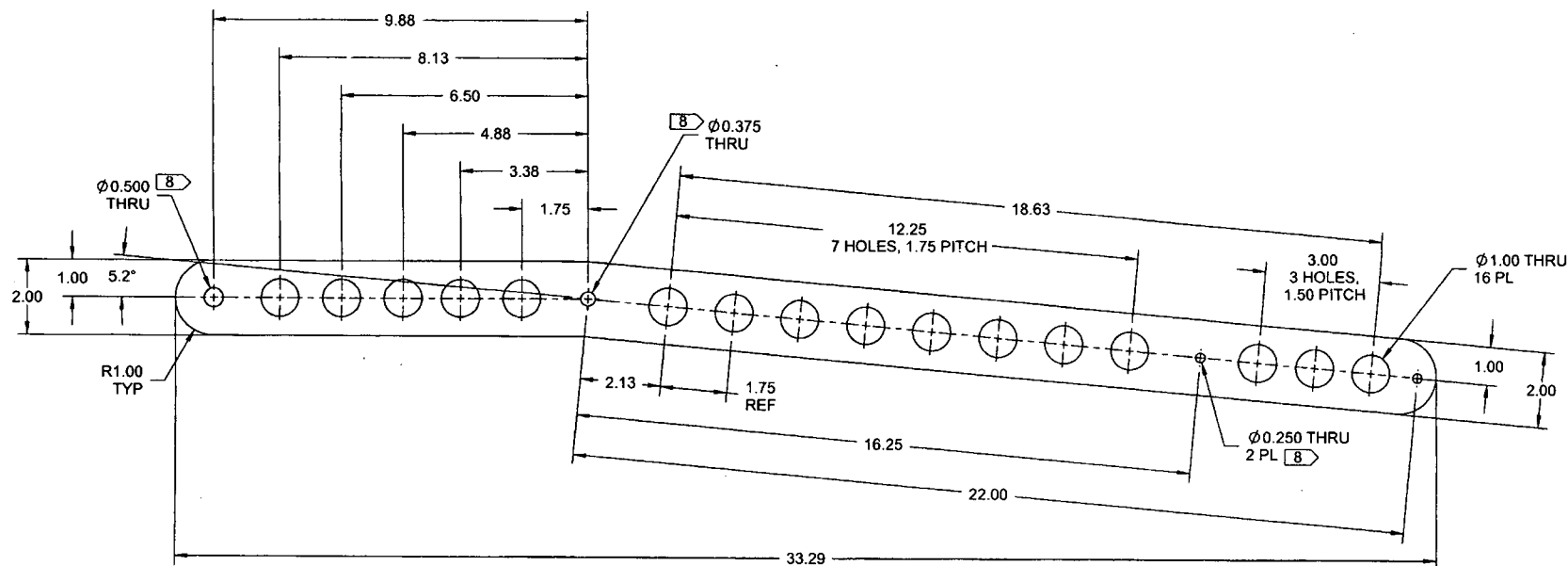
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**B67-43001-261 LEVER ARM**

# 62182

**RELEASED**  
2009-09-24

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025/4027  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREEN SANDING (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs
- 8) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 39 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>B67-43001-261</b> TITLE <b>LEVER ARM</b> SCALE <b>NTS</b> <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			
DATE	09.03.11			

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